



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D205-634-141
Job Sheet 203968



Part No: D205-634-141

Job Qty: 1 pcs

Part Name: Replacement Skidtube with Run-on Landing Wearplates Fits LH or RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/29/19

Job Tracking No:

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: D205-634 REV.I/ D2580 REV.H IPP RevA 11.09.14 new issue EC verified by:DD IPP REV:B 12.01.23 AS PER ECN11-684 DD VERF:EC IPP REV:C 13.03.21 AS PER ECN13-544 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier		Sign-off
							Workcenter / Supplier	Lead Time	
110	Skidtubes - 1	1 pcs	12/24/19		0.00	2.00	Skidtubes - 1		
							Skidtubes - 2		
							Skidtubes - 3		MLC
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
120	Skidtubes - Bend - 2 - B4B	1 pcs	12/24/19		0.50	1.00	Skidtubes - Bend - B4B		MLC
130	Skidtubes - 2 - B4B	1 pcs	12/24/19		0.00	2.00	Skidtubes - 1 - B4B		
							Skidtubes - 2 - B4B		
							Skidtubes - 3 - B4B		
							Skidtubes - 4 - B4B		TF
							Skidtubes - 5 - B4B		
							Skidtubes - 6 - B4B		
							Skidtubes - 7 - B4B		
140	QC 5	1 pcs	12/24/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		BE
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		



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CANADA
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Container No: S237040



Part: D205-634-141

Job No: 203968

Serial No/Batch: S237040

Revision: H/I

Inspector:

Exp Date:

Instructions: TC STC SH96-88 Issue 2, FAA-ETC SR005631

Plex 11/29/19 1:26 PM Dart.lajeunesse.marie

150 Skidtubes - 3 - B4B	1 pcs	12/24/19	0.00 2.00	QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				Skidtubes - 1 - B4B	
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	ML
160 QC 10	1 pcs	12/24/19	0.00 0.00	Skidtubes - 4 - B4B	
				Skidtubes - 5 - B4B	BE
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
				QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	
170 QC 5	1 pcs	12/24/19	0.00 0.00	QC 10 - 43	
				QC 10 - 50	
				QC 10 - 58	
				QC 10 - 9	
				QC 10 - 68	DEC 10 2019 DAS 68 9-89
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	DEC 10 2019 DAS 68 9-89
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
180 Handfinish - 2-1 Pressure- B4B	1 pcs	12/24/19	0.00 0.50	QC 5 - 61	
				QC 5 - 81	
				Handfinish - 2 - 1 - B4B	
				Handfinish - 2 - 2 - B4B	★ DEC 11 2019
190 Powdercoat - 1 White Gl(A)- B4B	1 pcs	12/24/19	0.00 0.80	Handfinish - 2 - 3 - B4B	
				Handfinish - 2 - 4 - B4B	
				Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	DEC 19-12-11
200 QC 3	1 pcs	12/24/19	0.00 0.00	Powdercoat - 3 - B4B	DEC 19-12-11
				Powdercoat - 4 - B4B	
				QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	ML 19-12-12
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	

					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
					210 Handfinish - 3-1- WingWalk-B4B	1 pcs
Handfinish - 3 - 2 - B4B	BEB 19-12-12.					
Handfinish - 3 - 3 - B4B						
Handfinish - 3 - 4 - B4B						
Handfinish - 3 - 5 - B4B						
220 QC 5	1 pcs	12/24/19	0.00 0.00	QC 5 - 10		
				QC 5 - 12		
				QC 5 - 17		
				QC 5 - 18		
				QC 5 - 19		
				QC 5 - 22		
				QC 5 - 24		
				QC 5 - 3		
				QC 5 - 43		
				QC 5 - 49		
				QC 5 - 51		
				QC 5 - 58		
				QC 5 - 68	DAS DEC 16 2019 68	
				QC 5 - 9	9-89	
				QC 5 - 50		
				QC 5 - 30		
				QC 5 - 40		
				QC 5 - 61		
				QC 5 - 81		
230 Packaging 3-1 - Stock - B4B	1 pcs	12/24/19	0.00 0.00	Packaging 3 - 1 - B4B		
				Packaging 3 - 2 - B4B		
				Packaging 3 - 3 - B4B		
				Packaging 3 - 4 - B4B		
				Packaging 3 - 5 - B4B		
				Packaging 3 - 6 - B4B		
				Packaging 3 - 7 - B4B		
				Packaging 3 - 8 - B4B		
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		

				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
235	DC - 1 - B4B	1	12/24/19	0.00 0.00	DC - 1 - B4B
	pcs				DC - 2 - B4B
240	QC 21 - FG	1	12/24/19	0.00 0.00	QC 21 - FG - 21
	pcs				QC 21 - FG - 70
					QC 21 - SA - 53
Part Op 110 - (Skidtubes)1- PICK D2580-1 2- SPOT DRILL 2 AFT RUN ON WEARPLATE HOLES USING DT10021, DRILL Descriptions: 3.630" HOLES USING DT8462 (83.94" FROM AFT OF D2580-1 REF. ONLY) 120 - (CNC Delta 100 Bender)1-Bend as per program D2580.C on CNC Bender and Folio FT 16 130 - (Skidtubes)1-Deburr ends after cutting and remove bending marks. Prepare tube for welding D2576-3 step remove alodine as required. 2-Locating from most fwd saddle hole, drill most fwd wearplate hole using DT9793 (10.832 REF) as per dwg D2580 sheet 7. 3-Open run-on wearplate holes to finished size 0.508" at locations (5.338/ 5.985/ 10.832/ 3.63 REF) as per dwg D2580 sheet 7. 4-Drill pilot holes for aft cap using DT8215, Open to finished size. 140 - (QC5- Inspect part completeness to step on W/O) 150 - (Skidtubes)1-Weld step D2576 as per Dwg. D2580 and QSI 004 A/R Aluminum Rod _____ 2-Touch up alodine on run on wearplate holes prior to swaging 3- Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002 and as per dwg 4-DRILL TOWING HOLE USING DT8091 5-DEBURR 160 - QC10- Inspect visual per QSI004- ground welds) 170 - QC5- Inspect part completeness to step on W/O) Production .0000 * Attachments 180 HandFinish And realodine tube as per QSI 005 HandFinish2 (Pressure Wash p 180 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings)And realodine tube as per QSI 005 190 - (White Gloss(Ref.4.3.5.1) per QSI005 4.3-Alum) START TIME: 1:05 OUT: 3:20 FINISH: 1:35 200 - (QC3- Inspect Part Finish)					

20/03

210 - (Assemble as per dwg)1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates A/R Sikaflex-291 ~~523665~~ 2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594 3- Install aft cap as per dwg 4- Wing walk as per dwg Batch# ~~5229693~~
220 - (QC5- Inspect part completeness to step on W/O)Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024
230 - 1 (Identify as per dwg & Stock Location:)Identify and pack for shipping as per PPPD205-634-141 Location : FG084
235 - (Document Control)Photocopy D205-634 bluefile & type labels per PPP D205-634-141 CHG004
240 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2580-1	205 Bent Tube	1 pcs (1 ea)	110-Skidtubes - 1	5224585
D2576-3	Step (Machining Detail)	1 pcs (1 ea)	150-Skidtubes - 3 - B4B	5177095
D4202-1	Spacer	24 pcs (24 ea)	150-Skidtubes - 3 - B4B	5188047
AN3-5A	Bolt	2 Ea (2 ea)	210-Handfinish - 3-1- WingWalk-B4B	5216385
AN4-45A	Bolt	8 Ea (8 ea)	210-Handfinish - 3-1- WingWalk-B4B	5228006
D2570	Bushing	16 pcs (16 ea)	210-Handfinish - 3-1- WingWalk-B4B	8x5221878/8x5232725
D2594-1	Plug	8 pcs (8 ea)	210-Handfinish - 3-1- WingWalk-B4B	5229062
D2594-3	O-Ring	8 pcs (8 ea)	210-Handfinish - 3-1- WingWalk-B4B	5045937
D2855	Cap	1 pcs (1 ea)	210-Handfinish - 3-1- WingWalk-B4B	5126188
D4406-041	Fwd Wearplate Assembly	1 pcs (1 ea)	210-Handfinish - 3-1- WingWalk-B4B	5190047
D4406-043	Aft Wearplate Assembly	1 pcs (1 ea)	210-Handfinish - 3-1- WingWalk-B4B	5198232
MS21042-4	Nut	8 Ea (8 ea)	210-Handfinish - 3-1- WingWalk-B4B	5158589
NAS1149D0332J	Washer	2 Ea (2 ea)	210-Handfinish - 3-1- WingWalk-B4B	5128378

m. u. 013423.

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D2580-1	1	10	0
150-Skidtubes - 3 - B4B	D2576-3	1	59	0
	D4202-1	24	1,222	0
210-Handfinish - 3-1- WingWalk-B4B	AN3-5A	2	199	0
	AN4-45A	8	29	0
	D2570	16	512	0
	D2594-1	8	188	0
	D2594-3	8	277	0
	D2855	1	67	0
	D4406-041	1	2	0
	D4406-043	1	2	0
	MS21042-4	8	68	0
	NAS1149D0332J	2	2,879	0

Part Specifications

Specifications could not be found.

ITEM	QTY -041	QTY -045	QTY -047	QTY -048	PART NUMBER	DESCRIPTION
1	X				D2880-041	SKIDTUBE ASSEMBLY
2		X			D2880-046	SKIDTUBE ASSEMBLY
3			X		D2880-047	SKIDTUBE ASSEMBLY
4				X	D2880-048	SKIDTUBE ASSEMBLY
20	1	1	1	1	D2880-1-100	EXTRUSION
21			16	16	D2870	BUSHING
22	1	1	1	1	D2878-3	STEP
23		4			D2870	SPACER
24	16	16	6	6	D2894-1	PLUG
25	16	16	6	6	D2894-3	O-RING
26	1	1	1	1	D2898	268 WEB
27	1	1	1	1	D2886	AFT CAP
28	1	1			D2894-8	WEARSHOE
29	1	1			D2894-9	WEARSHOE
30	1	1			D2884-11	WEARSHOE
31	1	1			D2894-13	WEARSHOE
32	20	20	24	24	D4002-1	SPACER
33			1		D4008-041	WEARPLATE ASSEMBLY
34			1		D4008-043	WEARPLATE ASSEMBLY
35				1	D6001-1	FWD WEARPLATE
36				1	D6001-3	AFT WEARPLATE
80	60	60			AL37-1002-130 or AN37-1002-130 or AN34-1002-130 or AN3-1002-130	INSERT
81	60	60			AN34A	BOLT
82	2	2	2	2	AN3-8A	BOLT
83			6	6	AN4-40A	BOLT
84	60	60			AN3114020002R	WASHER (AN300210L)
85	2	2	2	2	AN3114020002L	WASHER (AN300210R)
86			6	6	ME21042-1	NUT (CR ME21042L9)

GENERAL NOTES:

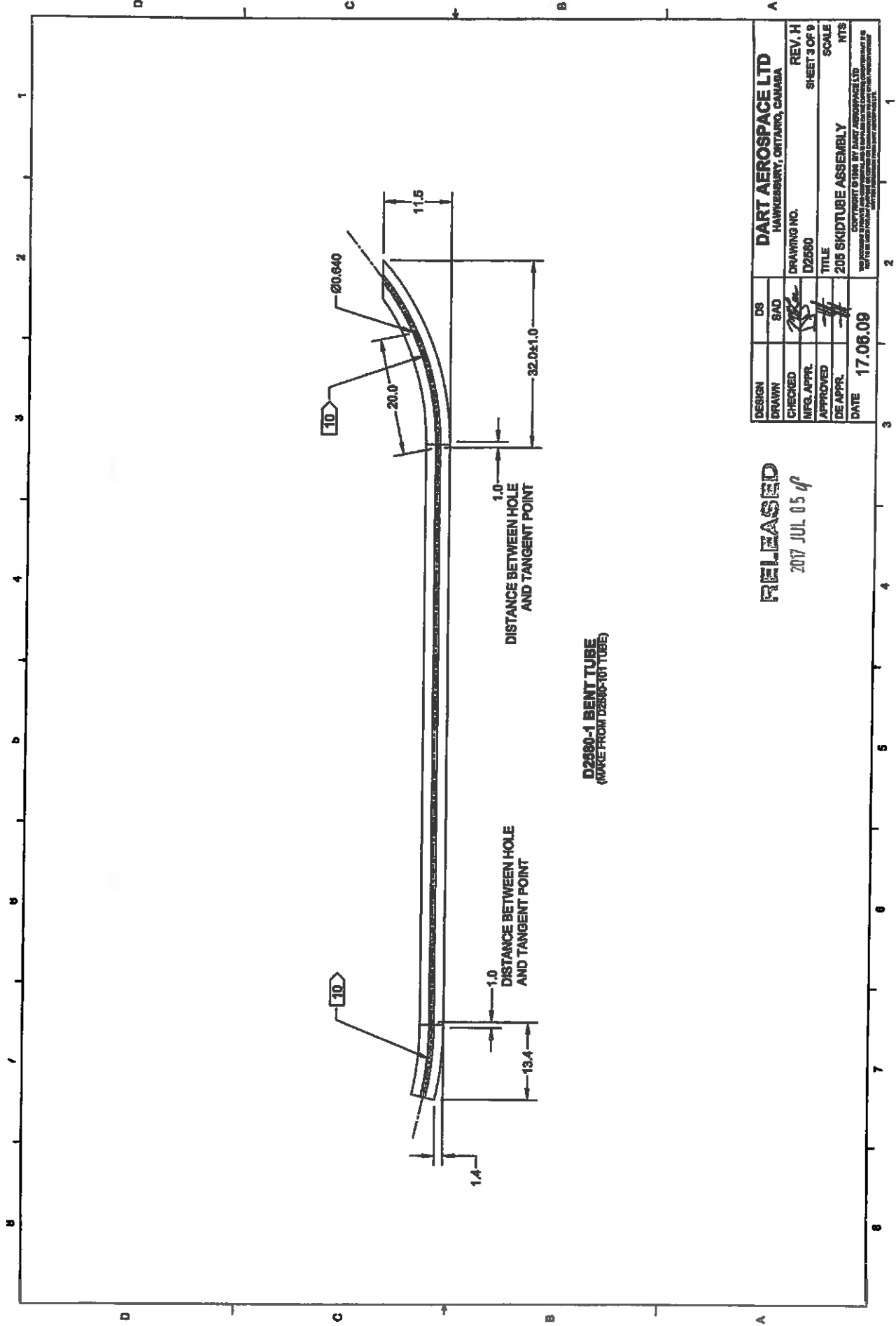
- 1) MATERIAL: NA
- 2) FINISH: CHEMICAL CONVERSION PER DART QBI 006 4.1 PRIOR TO INSERTING D2880 WEB POWDER COAT (-046) GREEN SANDTEX (REF 4.3.1.1) PER DART QBI 006 4.3 BLACK PTFE AND PAINT AS INDICATED PER DART QBI 006 4.4.
- 3) TOLERANCES: PER DART QBI 010 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D2880-041 = 33.7 lbs
D2880-045 = 33.7 lbs
D2880-047 = 46.1 lbs
D2880-048 = 52.0 lbs
- 8) WELDING PER DART QBI 004.
- 9) INSERT D2880 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL BRAD-FLEX-361 ADHESIVE PER DART QBI 018 BEFORE BONDING. ENSURE HOLES LINE-UP.
- 10) BONDING A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.300 IN DIAMETER IS ALLOWED IN THE BEST PORTION OF THE TUBE.
- 11) USE DART DRILL TEMPLATE DT8217 & DT8607 ONLY FOR D2880-041/046 TO LOCATE AND DRILL 60.027 HOLES FOR WEARSHOE INSERTS. INSTALL AL37-1002-130 PER SECTIONS B-B AND F-F (60 SPACES) AFTER FINISH. INSTALL AN34A BOLTS AND AN3114020002R WASHERS WITH SKID-LEX-2411-091.
- 12) INSERT D2880-1 PLUG CHW D2894-3 O-RING IN HOLES MARKED "P" (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES FOR D2880-041/045 AND 8 PLACES FOR D2880-047/048)
- 13) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2880 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

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WITHOUT NOTICE
WORK ORDER
NO. 200-1968-MUS
6711-29

H	SHEET: P1 DELETE D2880-045-13 GASKETS, WEIGHTS UPDATED ACCORDINGLY. SHEETS 2 & 4 PICTORIAL UPDATE FOR REMOVAL OF GASKETS	SAD	17.06.00
G	ADDED -046 -047 WEIGHT UPDATED PER DSI 0098	AJS	14.04.00
F	INCORPORATE DED D2880-E-1 PER PART 12-218	DC	13.06.20
E	ADD D2880-047 (2N CA-1) AND D2880-1 (2N 03-01) INCLUDED DED D2880-D-1; REFORMATTED DRAWING TO CURRENT STANDARDS; DT8217 & DT8607 WAS DT8217-205 (2N CA-1)	RF	11.06.21
D	CHANGE TO 88 WEARPLATES AND GASKETS,	PH	07.04.08
C	INCLUDE DED 11241 9183	CP	06.06.20
B	AS MANUFACTURED	DS	06.12.02
A	NEW ISSUE	DS	06.02.16
REV.	DESCRIPTION	BY	DATE
DESIGN	DS		
DRAWN	SAD		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	D2880	DRAWING NO.	REV. H
APPROVED	<i>[Signature]</i>	TITLE	SHEET 1 OF 8
DATE	17.06.00	SCALE	NTS

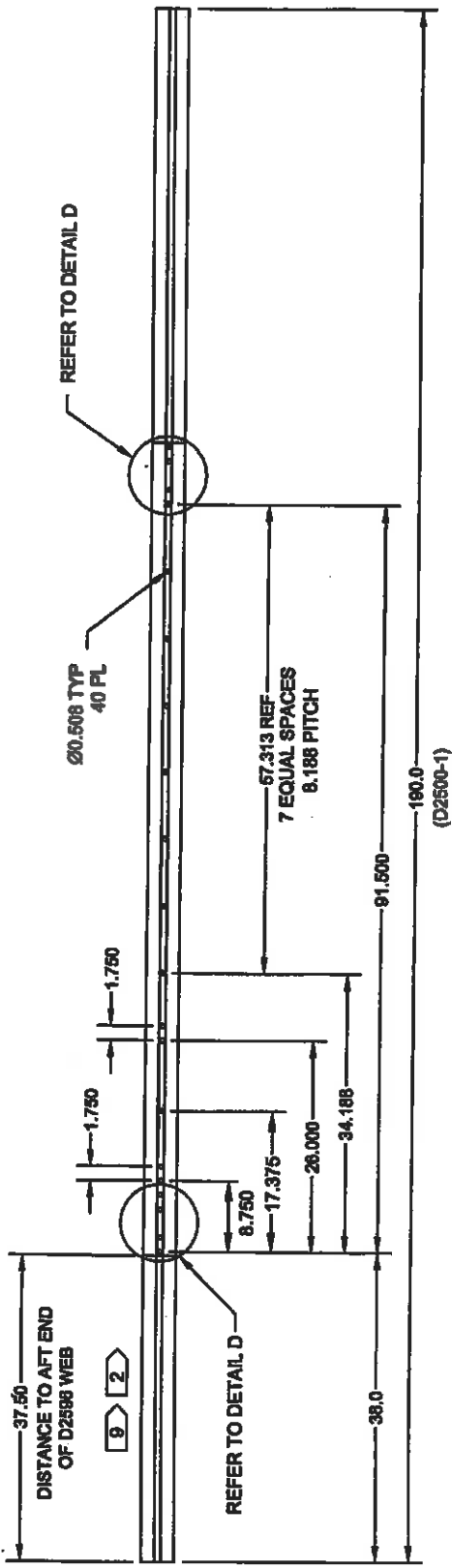
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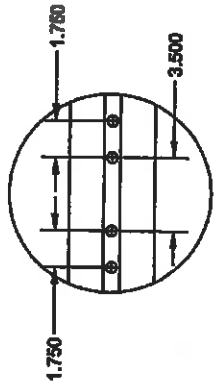


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2017 JUL 05

DESIGN	DS	DART AEROSPACE LTD
DRAWN	SAD	HAWKSBURY, ONTARIO, CANADA
CHECKED		DRAWING NO.
INFG. APPR.		D2580
APPROVED		REV. H
DE APPR.		SHEET 3 OF 9
DATE	17.06.09	TITLE
		205 SKIDTUBE ASSEMBLY
		SCALE
		NTS
		NOT TO BE USED FOR ANY OTHER PURPOSES WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.



D2580-101 TUBE



DETAIL D
SCALE 5X

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2017 JUL 05

DESIGN	DS	DART AEROSPACE LTD HAMMERSBURY, ONTARIO, CANADA
DRAWN	SAD	
CHECKED	MS	DRAWING NO. D2580
INFS. APPR.		REV. H SHEET 8 OF 8
APPROVED		TITLE 205 SKIDTUBE ASSEMBLY
DE APPR.		SCALE NTS
DATE	17.06.09	

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